

DRAB GREEN

Work Order ID 149746 -1 split
Thursday, July 28, 2016 8:30:52 AM

149746

Item ID: D2646

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Cap

Start Date: 7/28/2016 Start Qty: 10.00

1A

Required Date: 7/28/2016 Req'd Qty: 10.00

1A

Cust Item ID:

Reference: drab green

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2646

Rev C

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.03

Hand Finishing

155

0.00

155

SprayPaint

Memo

0.00

Spray Painting

PULL FROM STOCK
BX D2646 B136885
2 x D2646 B141214
SCUFF LIGHTLY
PRIME B 135172
SRPAY PAINT DRAB GREEN B 135413

h

2

DAS
41
9-89
14-09-16

Work Order ID 149746

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Page 2

Item ID: D2646

Revision ID:

Item Name: Aft Cap

Start Date: 7/28/2016 Start Qty: 10.00

Required Date: 7/28/2016 Req'd Qty: 10.00

Reference: drab green

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

175

QC14- Inspect Spray Paint

0.00

175

QC

Memo

0.00

Quality Control

x2 of 16/09/15

180

Small Fab

0.00

180

Small Fab

Memo

0.05

Small Fab

Install inserts as per Dwg D2646

2x of 16/09/15

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.03

Quality Control

2 of 16-09-15 23 34 08

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Item ID: D2646

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cap

Start Date: 7/28/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/28/2016 Req'd Qty: 10.00

10

Customer:

Reference: drab green

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Identify as per dwg & Stock Location: FP001

0.00

200

Packaging

Memo

0.02

Packaging

LOCATION : FP001

x2 d 16/09/15

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.17

Quality Control

DAS
21
9-89

SEP 16 2016

4667-15

2m 16/09/15

Picklist Print

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Page 1

Work Order ID: 149746

149746

Parent Item: D2646

D2646

Parent Item Name: Aft Cap

Start Date: 7/28/2016

Required Date: 7/28/2016

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: G05.08.22Hole size revised in Step 5KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130	AELS8-1032-130	Purchased	No				Each	1,262.000		2 4		all 16/06/15	
AI S7-1032-130									**				
Rivnut													

Location	Loc Qty	Loc Code
FG	100	
M128649	100	
FP001	13	
M128649	13	
st549	1149	
M128649	1149	
	Each	37.0000

D2646

Manufactured No

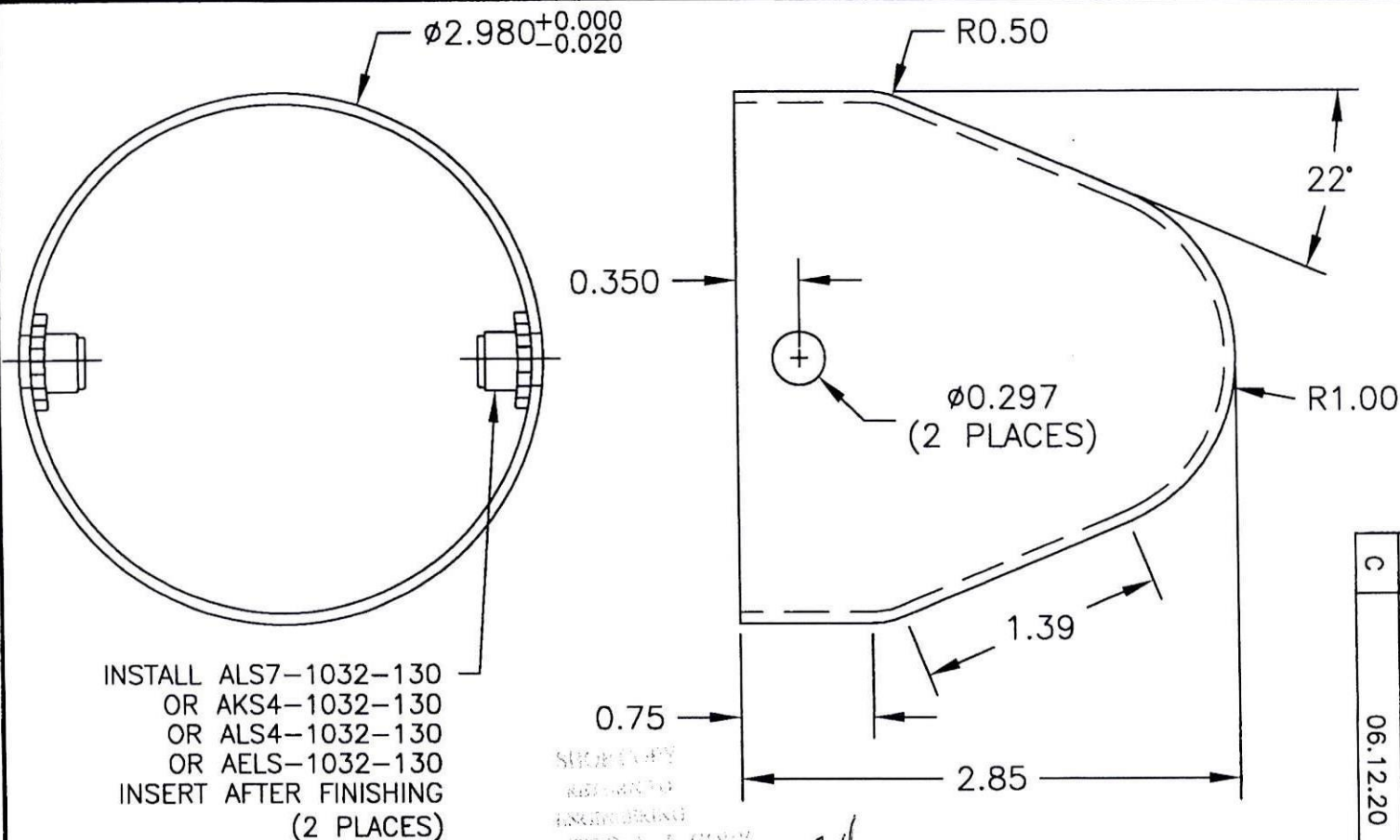
D2646

Aft Cap

Location	Loc Qty	Loc Code
FG	4	
85848	2	
90495	2	
FP001	33	
127924	1	
136885	2	
141214	30	

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED		APPROVED		DRAWING NO.	D2646	SHEET 1 OF 1
DATE	06.12.20	TITLE	AFT CAP	SCALE	1:1	
A	97.03.25	NEW ISSUE				
B	05.04.01	CHANGE TO CLOSED INSERTS				
C	06.12.20	CHANGE TO OPEN ENDED INSERTS				



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

07.02.12